

# Work Order ID 52927

October 19, 2009 10:58:07 AM

Page 1

Item ID: D3957-044

Accept

Revision ID: A

Item Name: Hinge Assembly, Door RH Lower

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 4.00

Required Date: 11/02/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *RL*

Date: *07-10-19* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3957	A								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
			<i>= 7 m-h 04/11/30</i>						
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1-Install Helicoil in d3957-4								
	2-Install Rod end and Nut Loosely								
			<i>= 7 m-h 04/11/30</i>						
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
			<i>= 8 01/11/30</i>						

*8X*

*8X*

*8X*

# Work Order ID 52927

October 19, 2009 10:58:07 AM



Page 2

Item ID: D3957-044

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Assembly, Door RH Lower

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 135

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Pa 9/12/01 E*

*09/12/01 H*

*MF 09-12-01*

# Picklist Print

October 19, 2009 10:58:12 AM

Page 1

Work Order ID: 52927

Parent Item: D3957-044A-PRELIM

Parent Item Name: Hinge Assembly, Door RH Lower

Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3518-3RevB

Manufactured

No

100

Each

18.0000

4.0000



Stainless Steel Ball Joint Rod End

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48211

3

3

Main Warehouse

ST109

15

51108

5

52270

10

MS124818

Purchased

No

100

Each

50.0000

4.0000



Helicoil

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112503

50

50

D3957-4A-PRELIM

Manufactured

No

100

Each

0.0000

4.0000



Hinge, Door RH Lower

4X m-l 09/11/30

4X m-l 09/11/26

4X m-l 09/11/30

4 m-l 09/11/26

B 53958 =>

(8X) m-l 09/11/30

# Picklist Print

October 19, 2009 10:58:12 AM

Work Order ID: 52927



Parent Item: D3957-044A-PRELIM



Parent Item Name: Hinge Assembly, Door RH Lower

Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-6		Purchased	No			100	Each	18.0000	4.0000			



Nut



*X*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

109249

8

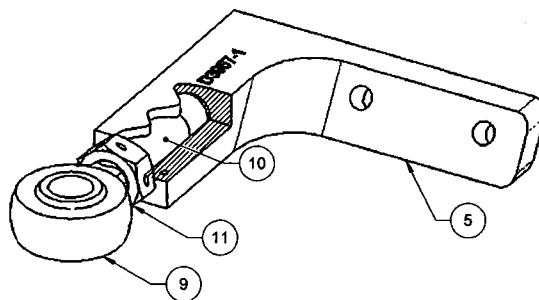
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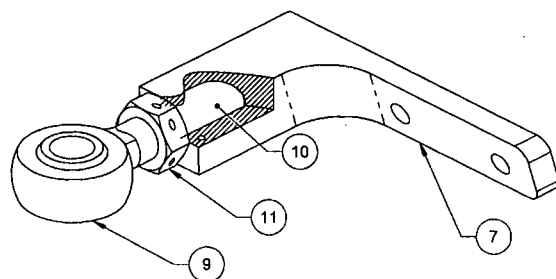
*M 113147*

*8X m-l 09/11/30*

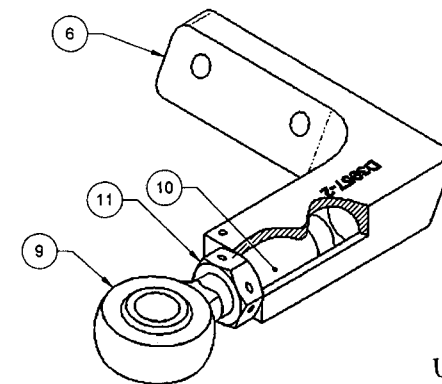
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1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



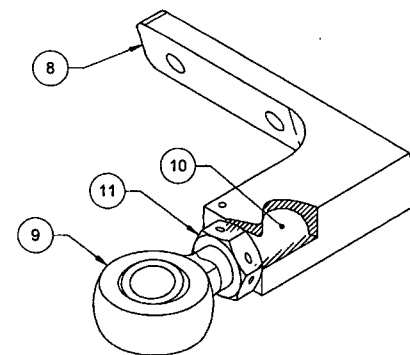
**D3957-041 HINGE ASSY, DOOR LH UPPER**



**D3957-043 HINGE ASSY, DOOR LH LOWER**



**D3957-042 HINGE ASSY, DOOR RH UPPER**

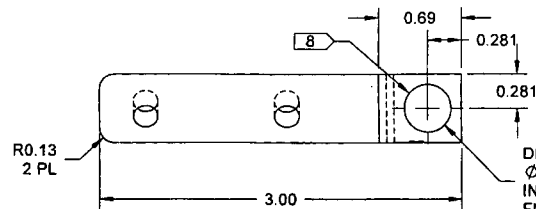


**D3957-044 HINGE ASSY, DOOR RH LOWER**

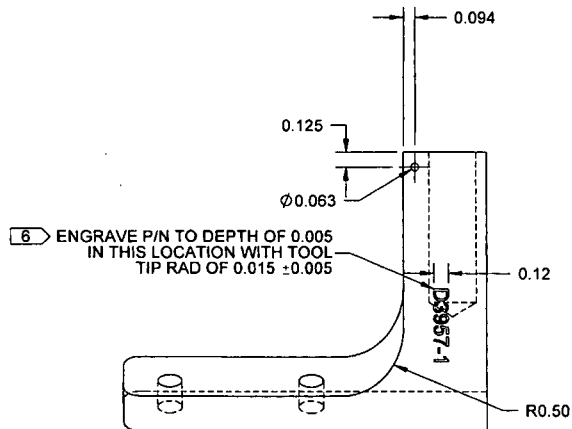
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WITHOUT THE  
WORK ORDER  
NO. 52927

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2009-10-08  
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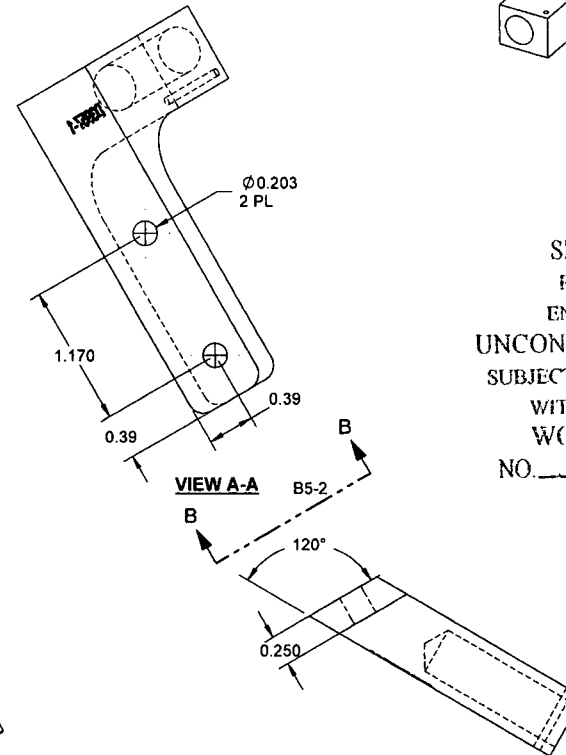
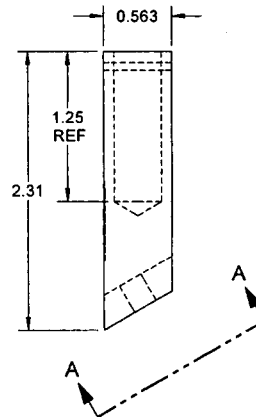
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DRAWN	AB			SHEET 1 OF 5	
CHECKED	PH	DRAWING NO. D3957		SCALE	
MFG. APPR.	21	TITLE HINGE		NTS	
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DE APPR.	14				
DATE	09.09.03				



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm$  0.005



VIEW A-A

VIEW B-B

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 WORK ORDER NO. 52927

**D3957-1 HINGE, DOOR LH UPPER**

**NOTES:**

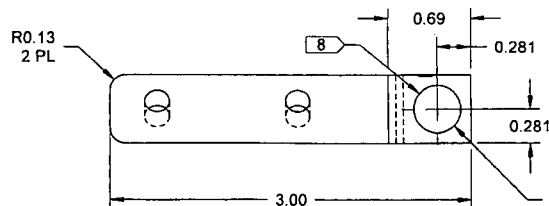
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 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	DE	<b>DART AEROSPACE LTD</b>	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
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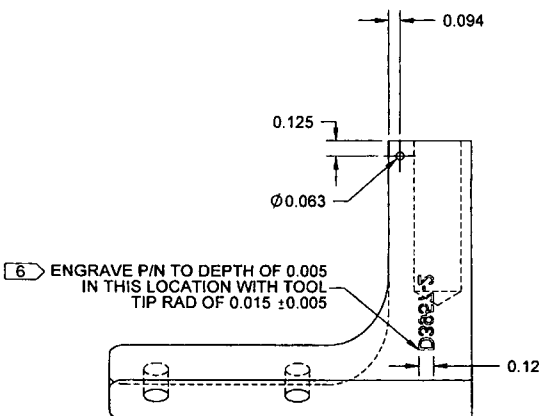
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 2009-10-08

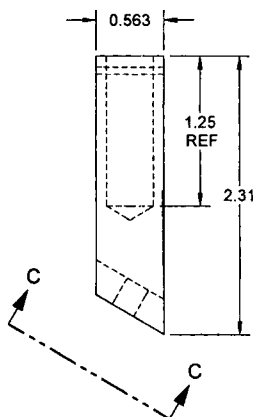
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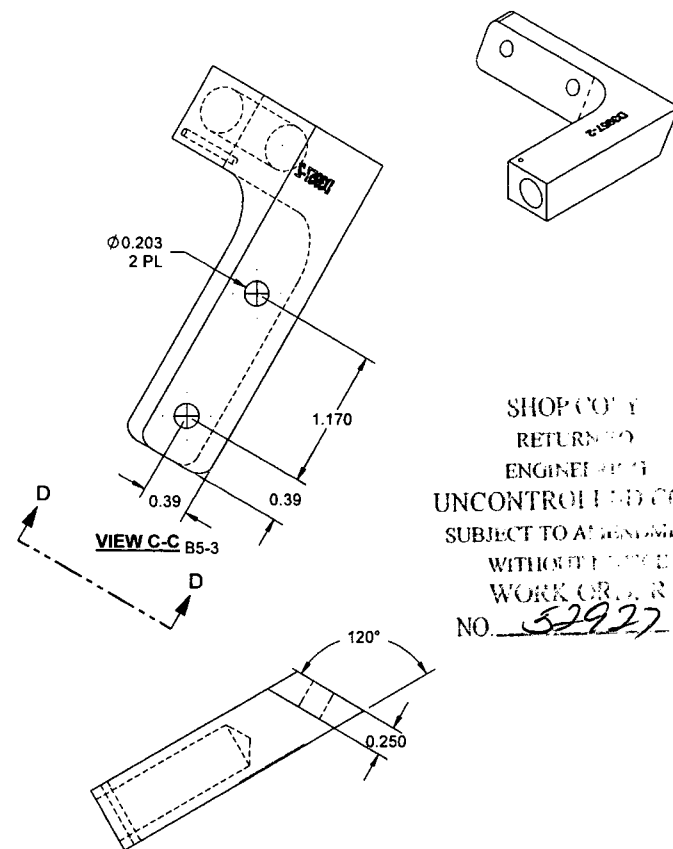
DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\phi 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm$  0.005



**D3957-2 HINGE, DOOR RH UPPER**



**VIEW C-C**

**VIEW D-D**

C3-3

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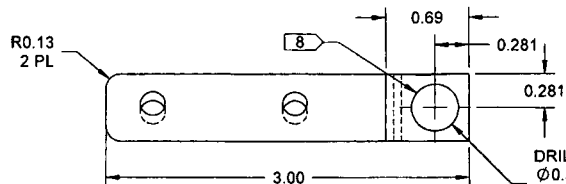
**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

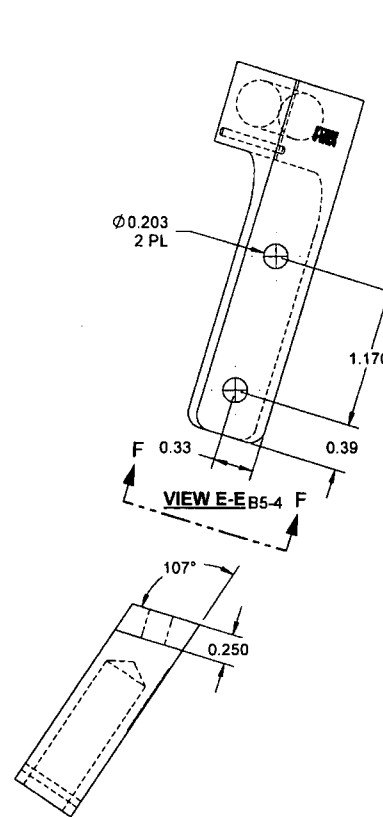
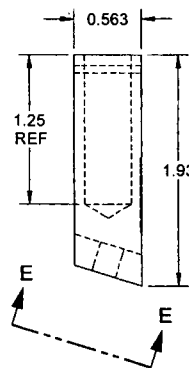
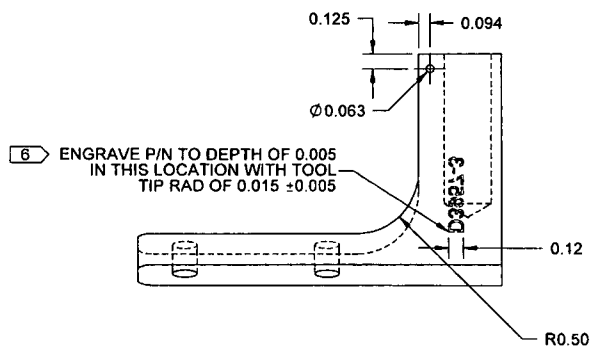
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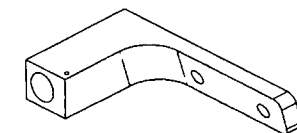
8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



VIEW F-F C3-4



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 WORK ORDER NO. 32927

RELEASED  
 2009 -10- 08  
 MAD

D3957-3 HINGE, DOOR LH LOWER

NOTES:

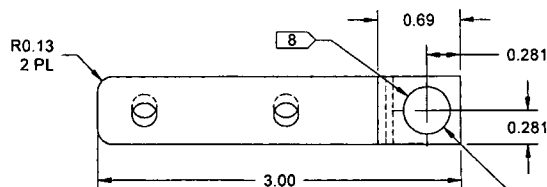
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
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 REF DART SPEC M6061T6B
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 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	DES	DART AEROSPACE LTD	
DRAWN	DES	HAWKESBURY, ONTARIO, CANADA	
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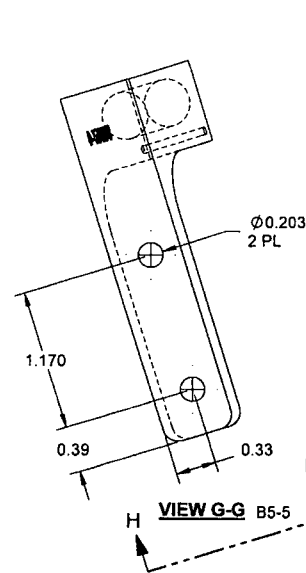
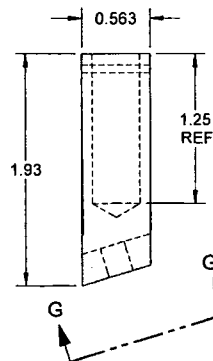
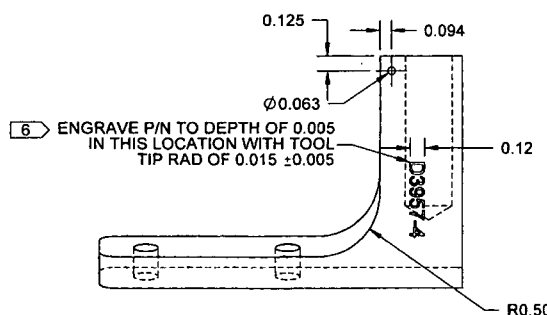
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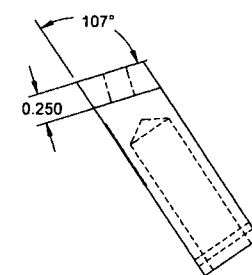
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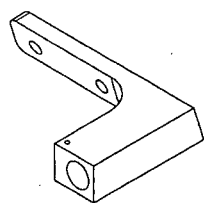
DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



VIEW G-G B5-5



VIEW H-H C3-5



SHOWN  
 RELEASED  
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 UNCONTROLLED  
 SUBJECT TO  
 WITH  
 WORK  
 NO. 52927

**D3957-4 HINGE, DOOR RH LOWER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

**RELEASED**  
 2009-10-08  
*Red*

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
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CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>21</i>	D3957	SHEET 5 OF 5
APPROVED	<i>12</i>	TITLE	SCALE
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